

Date: Tuesday, 30/09/2008 11:14:27 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE SPACER		
Job Number	: 42364			Part Number	: D2876		
Estimate Number	: 10764			Drawing Number	: D2876 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/09/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	: NOTE:1 BLANK MAKES 4 PARTS		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/10/2008	Qty:	200
Previous Run	: 38662			Um:	Each		
Written By	: <u>JUO 08.9.30</u>						
Checked & Approved By	: <u>JUO 08.9.30</u>						
Comment	: Esr Rev:B 00.05.19 Added inspect level 8 EC						
	Est Rev:C Now M6061-T6 06-06-23			JLM			

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

Barcode:

21 0-2542-5611-1 T-11 10-2000

Qty.: 0.0542 sf(s)/Unit Total : 10.8360 sf(s)
Material: 6061-T6 (QQ-A-250/8) 0.100" Thick
Batch: 8228 13 8-11-16

20 WATER JET FLOW WATER JET

1-Cut as per Dwg D

1-out as per Long B 2070

Dwg Rev: A3
Prog Rev: R

Prog Rev. 13

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 ~~SECOND CHECK~~

A standard linear barcode is positioned horizontally across the page, consisting of vertical black lines of varying widths on a white background.

59 SMALL EAR 1 SMALL & MEDIUM EAR RESOURCE 1

Comment: SMALL & MEDIUM EAR RESOURCE 1

Remove tabs and Tumble

NRA 1

well deserved @ 2.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 11:14:27 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 42364

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

90

08-11-18298

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ

08/11/13

298

8.0 PACKAGING 1

PACKAGING RESOURCE #1



298X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 52

811113

5P

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/14 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.11.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42364
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>ML</u>	Prototype Approval: N/A
Date: 8-10-11	Date: 08-11-11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.15	Removed 0.250 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

11

DART

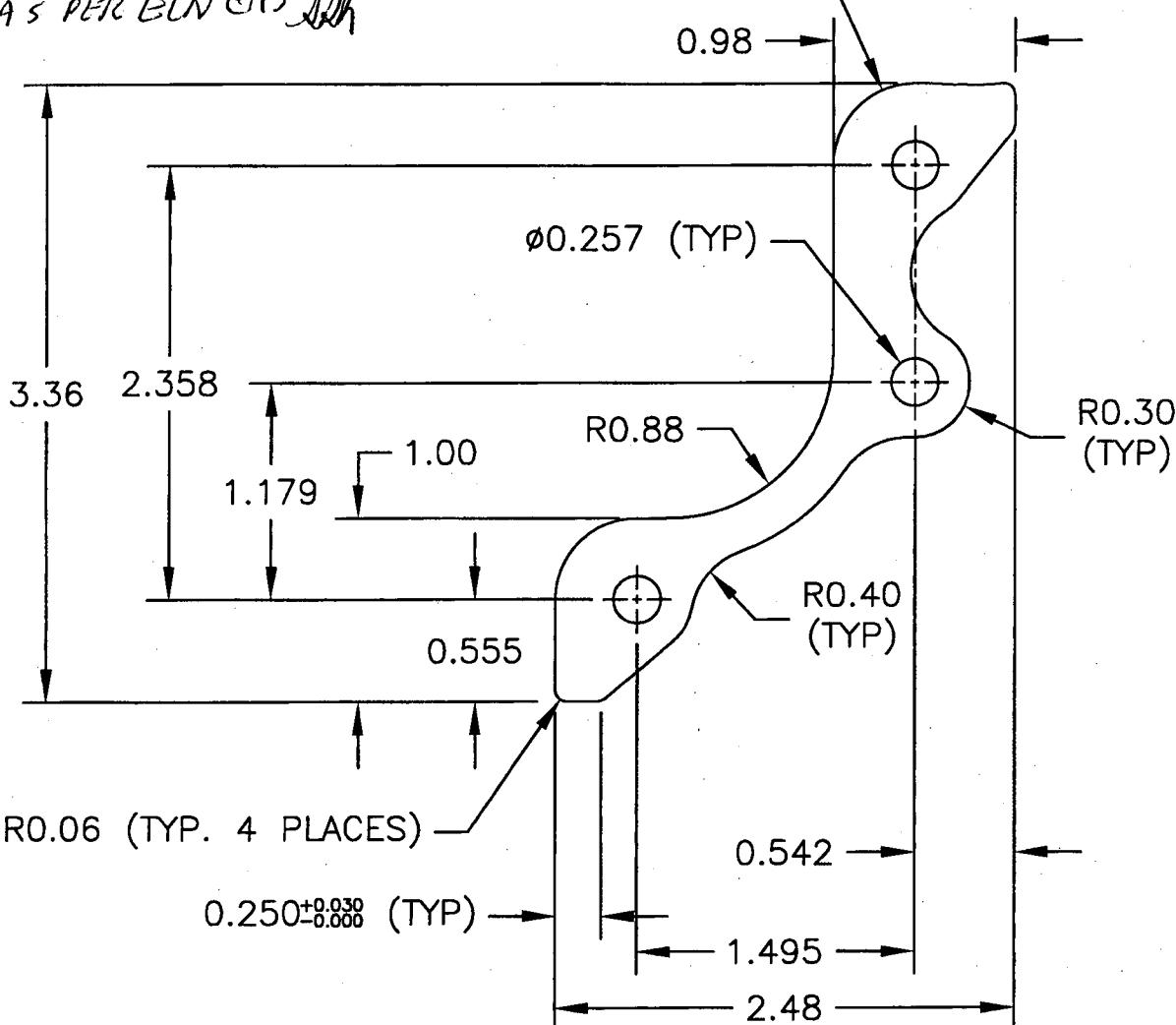
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	MM	D2876	SHEET 1 OF 1
DATE		TITLE	SCALE
06.06.02		SADDLE SPACER	1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED

06.06.22

AS PER ECN 813

R0.44 (TYP 2 PLACES)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 42304

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